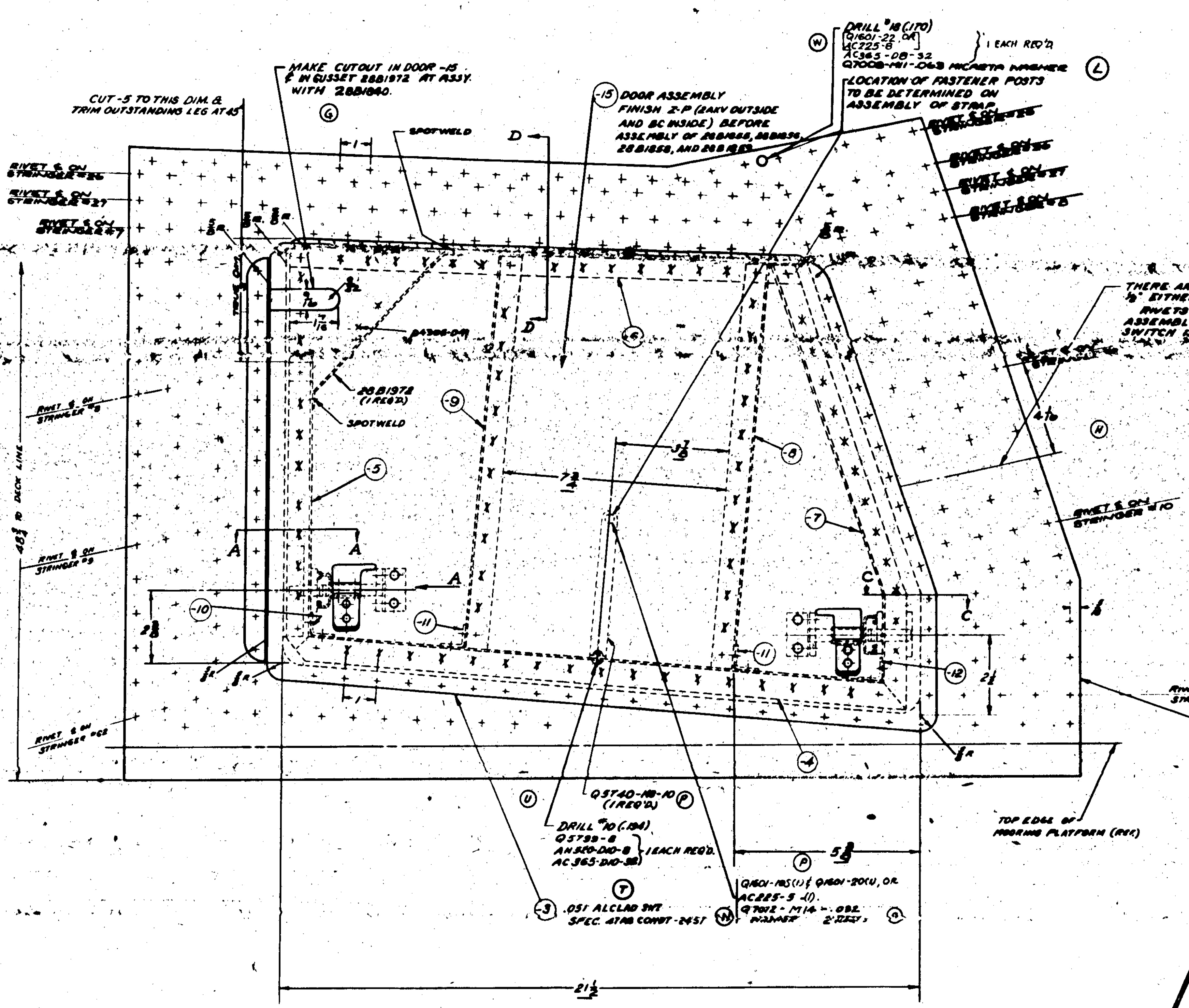
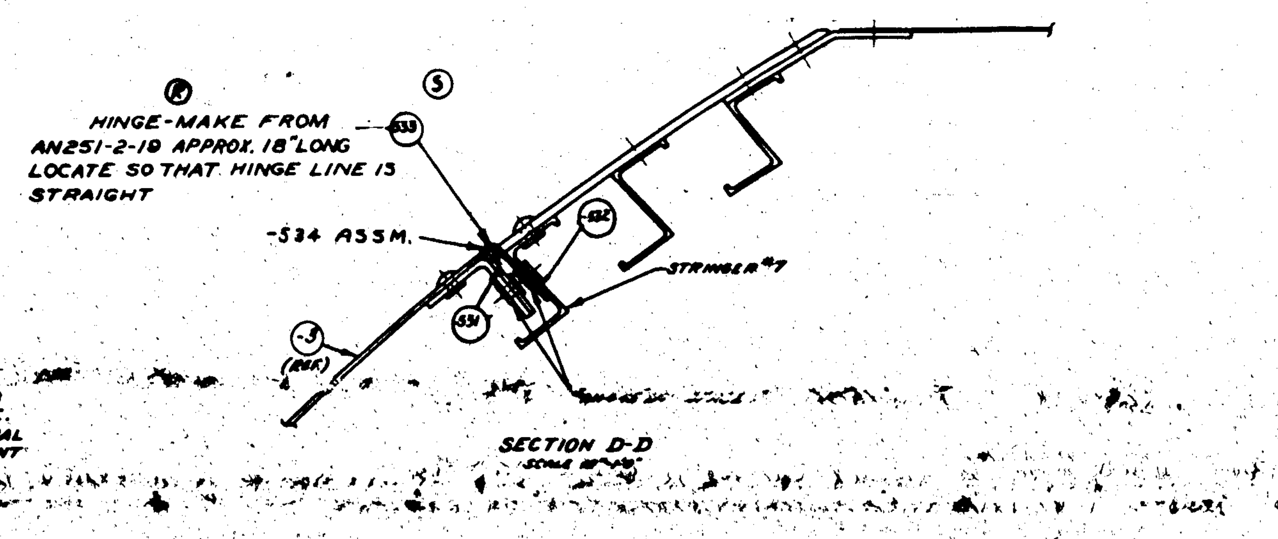
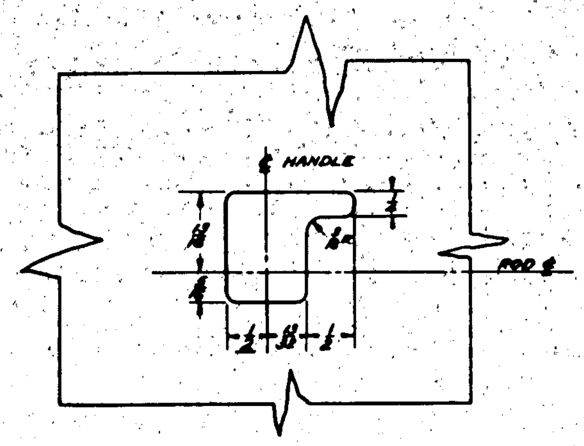
LTR	ALTERATION	DATE	BY
F	TRACED UP TO DATE		
G	DIMENSIONS ADDED TO SLOT IN -15 DOOR. NOTE CHANGED	1-22-37	
H	DIM. WAS		
J	MADE DWG. LIKE DOOR HAS BEEN MADE ON ALL SHIPS, RELOCATING -8 ANGLE.		
K	CHANGED -4 TO -12 INCL., EXCEPT -7, FROM S.O. TO S.T. MAT'L. -7 TO REMAIN S.O. OMITTED ROUNDED EDGES ON -2 & -13.	11-16-37	
L	ADDED Q7008-M11-.063 MICARTA WASHER BETWEEN LIFT THE DOT FASTENER POST AC225 -8 & HULL SKIN. ALSO ADDED Q7008-M11-.063 (1 REQ'D) TO B/M.		
M	-2 & -3 WERE 47A10 COND A	12-30-37	
N	QTY 28B1974 WAS 2.		
O	ADDED Q7012-M14-.032		
P	AC225-1 REMOVED Q5740-K1-10 WAS Q5740-K1-10		
Q	NOTE ADDED		
R	NOTE REVISED		
S	REMOVED -14 & ADDED -534 -531 -532 -533		
T	-3 .051 ALCLAD SHT. SPEC. 47A8 COND T-24ST WAS .051 AL. ALLOY SHT. SPEC. 47A10 COND. T ALLOY 24T. NOTE FOR -4 -5 -6 -8 -9 -10 -11 & -12 DIE # K5401 SPEC 46A10 COND T WAS DIE # K5401 SPEC 46A10 COND T. NOTE FOR -7 DIE # K5401 SPEC 46A10 COND A- HEAT TREAT SR-53 COND T WAS DIE # K5401 SPEC. 46A9 COND A. NOTE ADDED "SPOTWELD --- (DOOR ASS'Y)". IN -15 REMOVED RIVET SYMBOLS & REPLACED WITH SPOT-WELD SYMBOLS EXCEPT IN ENDS OF SPOTWELD MEMBERS. WT. CHG. NEG.	3-16-43	
U	Q5740-K9-10 WAS Q5740-K1-10 WT. CHG. NEG.		
V	REMOVED NOTE: "MAKE -4 -5 -6 -8 -9 -10 -11 -12 FROM ... PLAIN ANGLE, DIE # K5401 SPEC 46A10 COND T ... -7 FROM ... PLAIN ANGLE, DIE # K5401 SPEC 46A10 COND A HEAT TREAT SR-53 COND T." ADDED MAT'L NOTE. WT. CHG. NEG.		
W	IN B/M, ADDED "Q1601-195(1) Q1601-20(1) Q1601-22(1)" AT AC225-5 AC225-8, Q1601-195, Q1601-20, Q1601-22, ADDED "SEE NOTE" ON FACE. REPLACED CALLOUT AC225-5 WITH NOTE "Q1601-195 & Q1601-20, OR AC225-5". REPLACED CALLOUT AC225-8 WITH NOTE "Q1601-22 OR AC225-8." NO WT. CHG.	8-20-43	HODIK







DETAIL OF FRONT SLOT IN SKIN (-3) FOR HANDLE OPERATION: REAR SLOT IS IDENTICAL BUT OPPOSITE HAND FROM FRONT SLOT - RADII NOT OTHERWISE SPECIFIED - 1/16

ALL RIVETS Q4305-D4 EXCEPT AS NOTED.

FORM TO CONTOURS SHOWN ON 28-3 1852.

(T) MATERIAL NOTE-

(V) 1-MAT'L. FOR -4, -5, -6, -7, -8, -9, -10, -11, & -12 MAY BE-

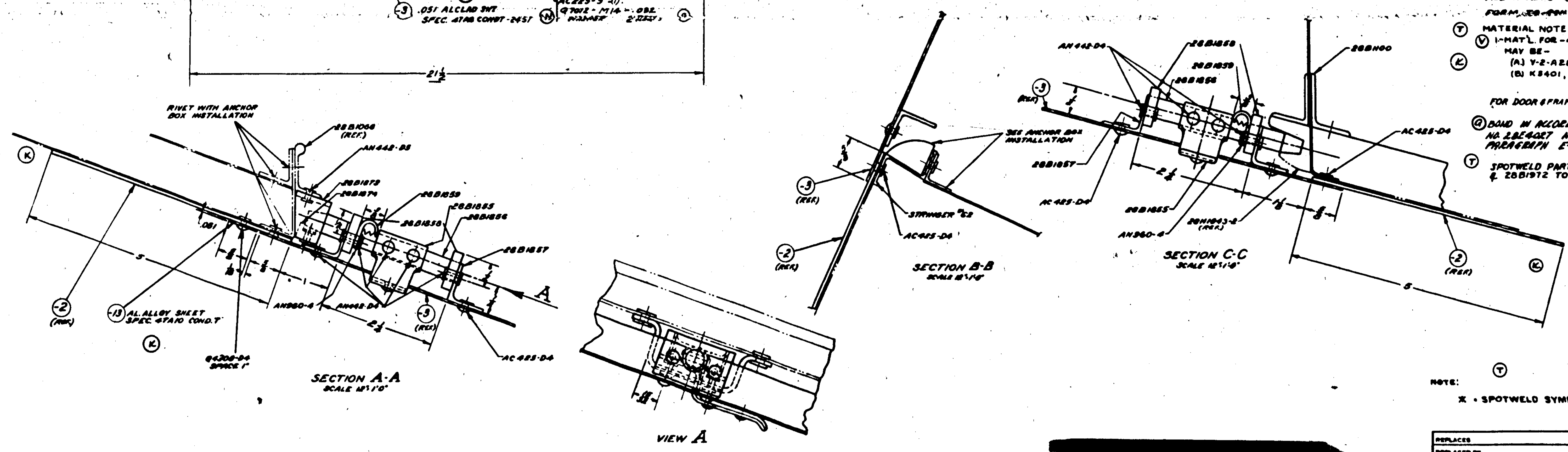
(A) Y-2-A28T, OR

(B) K5401, ALAL. EXTR., SPEC QQ-A-331-T.

FOR DOOR & FRAME OUTLINES USE SHOP TEMPLATES

(Q) BOND IN ACCORDANCE WITH BONDING REPORT NO. 28E4027 ANY SE166 FIGURE 22 ALSO PARAGRAPH E-4F.

(T) SPOTWELD PARTS -3, -4, -5, -6, -7, -8, -9, -10, -11, -12, & 28B1972 TO COMPLETE -15 ASSY (DOOR ASS'Y).



(T) NOTE:

X = SPOTWELD SYMBOL

28-5AMA	28B1840	1	-534		
28-5MA	28B1840	1	-15		
28-5MC	28B1840	1	-12		
28-5MA	28B1840	1	-11		
28-5ME	28B1840	1	-10		
28-5AMC	28B1840	1	-9		
PBY-5B	28B1840	1	-8		
PBY-5A	28B1840	1	-7		
PBY-5	28B1840	1	-6		
PBY-4	28B1840		-5		
PBY-3	28B1840		-4		
PBY-2	28B1840		-3		
PBY-1	28B1840		28B1850-2		
O.H.	MODEL	NEXT ASSY / REQ	PART NO.		
	REQUIREMENTS PER AIRPLANE		PARTS LIST PER ASSY		

REPLACES		APPROVED 10-18-36	DATE
REPLACED BY		CALC. WT.	ACT. WT.
LIMIT ON DIMENSIONS UNLESS OTHERWISE SPECIFIED ± 1/64		SCALE	
[redacted]		NAVY NOTED	NOTED / NOTED / Z-P
		MATERIAL	SPEC. / HEAT TREAT / FINISH
FINISH CODE		CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.	NAME: DOOR INSTALLATION HULL- ANCHOR BOX

J 28B1850

H 103